



Europäisches Patentamt
European Patent Office
Office européen des brevets

(11) Publication number:

0 210 891
A3

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: 86401432.9

(51) Int. Cl. 4: B22D 11/06

(22) Date of filing: 27.06.86

(30) Priority: 27.06.85 JP 96576/85
30.08.85 JP 189965/85
14.04.86 JP 84234/86
16.04.86 JP 86204/86

(43) Date of publication of application:
04.02.87 Bulletin 87/06

(84) Designated Contracting States:
AT BE CH DE FR GB LI

(88) Date of deferred publication of the search report:
15.03.89 Bulletin 89/11

(71) Applicant: KAWASAKI STEEL CORPORATION
1-28, Kita Hom-Machidori 1-Chome
Chuo-Ku, Kobe-Shi Hyogo-Ken(JP)

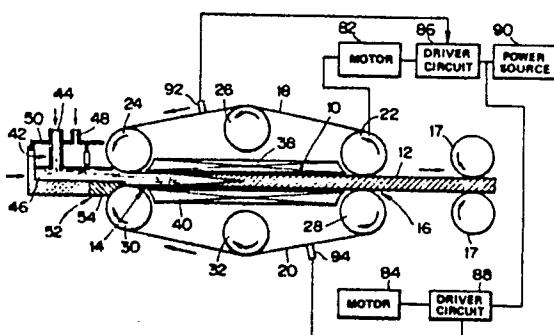
(72) Inventor: Itoyama, Seiji
1, Kawasaki-cho
Chiba-shi Chiba-ken(JP)
Inventor: Nakato, Hakaru
1, Kawasaki-cho
Chiba-shi Chiba-ken(JP)
Inventor: Nozaki, Tsutomu
1, Kawasaki-cho
Chiba-shi Chiba-ken(JP)
Inventor: Habu, Yasuhiro
1, Kawasaki-cho
Chiba-shi Chiba-ken(JP)
Inventor: Bessho, Nagayasu
1, Kawasaki-cho
Chiba-shi Chiba-ken(JP)
Inventor: Fujii, Tetsuya
1, Kawasaki-cho
Chiba-shi Chiba-ken(JP)

(74) Representative: Nony, Michel
Cabinet NONY & CIE 29, rue Cambacérès
F-75008 Paris(FR)

(54) Method and apparatus for casting endless strip.

A3
EP 0 210 891
EP A method and apparatus for continuous casting of an elongated thin metal strip achieves substantially high yield without allowing break-out or sticking. The method for casting a continuous elongated metal strip according to the present invention includes a step of driving endless belts at a varying speed so as to apply jerks to the slightly and half-solidified metal that release the metal from the surfaces of the stationary side walls. Applying jerks to the casting chamber by varying the driving speed of the endless belt ensures that the solidifying metal will travel smoothly and thus ensures a high manufacturing yield.

FIG. 1





DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
X	EP-A-0 092 844 (HAZELETT STRIP-CASTING CORP.) * Figures 4,3; page 16, lines 10-31; page 19, lines 21-26 *	26-30	B 22 D 11/06
A	---	22-25	
X	PATENT ABSTRACTS OF JAPAN, vol. 8, no. 220 (M-330)[1657], 6th October 1984; & JP-A-59 104 256 (SUMITOMO KINZOKU KOGYO K.K.) 16-06-1984 * Abstract *	26-30	
A	---		
A	DE-A-3 207 091 (HITACHI LTD) * Page 17, line 24 - page 18, line 1; claim 1 *	1,5,8-10,20	
A	---		
A	PATENT ABSTRACTS OF JAPAN, vol. 5, no. 131 (M-84)[803], 21st August 1981; & JP-A-56 68 569 (ISHIKAWAJIMA HARIMA JUKOGYO K.K.) 09-06-1981 * Abstract *	1,5-6,8-10,20	
P,A	---		
P,A	PATENT ABSTRACTS OF JAPAN, vol. 10, no. 138 (M-480)[2195], 21st May 1986; & JP-A-60 261 649 (SUMITOMO KINZOKU KOGYO K.K.) 24-12-1985 * Abstract *	1,5-6,8-10,20	
A	---		
A	DE-A-2 237 508 (SCHLOEMANN) * Claim 1 *	1,8-10,20	

The present search report has been drawn up for all claims			
Place of search		Date of completion of the search	Examiner
THE HAGUE		12-12-1988	DOUGLAS K.P.R.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document			
T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			